

Date: Thursday, 30/10/2008 1:45:51 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : VERTICAL TUNNEL TOP
<b>Job Number</b> : 43099	
<b>Estimate Number</b> : 13588	
<b>P.O. Number</b> :	<b>Part Number</b> : D38225
<b>This Issue</b> : 30/10/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D38225 UNDER REVIEW 08.11.03 PK
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : IN0002
<b>First Issue</b> : // <b>Type</b> : R&D THERMOFORMING	<b>Drawing Revision</b> : A UNDER REVIEW
<b>Previous Run</b> : 42070	<b>Material</b> : MKYDEX6185S80P362015
<b>Written By</b> :	<b>Due Date</b> : 06/11/2008 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est. A New Issue 08/09/17 DL	

## Additional Product

**PROTOTYPE**  
 PLEASE RETURN ALL ISSUED  
 DATA TO ENGINEERING

Job Number:



30/10/2008 DL

Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MKYDEX6185S80P362015	Kydex velour matte, ivory
-----	----------------------	---------------------------



**Comment:** Qty.: 1.5000 sf(s)/Unit Total : 3.0000 sf(s)  
 Kydex velour matte, ivory

14109703

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------



**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

08/11/03 Oh

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------



**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

08/11/03 Oh

4.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------



**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3822-5 and folio (FTA 9078 Prototype) using tool DT 9078

Dwg. Rev. A UNDER REVIEW  
 Folio Rev. A

08/11/03 Oh

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

08/11/03 Oh

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL TOP

Job Number: 43099

Part Number: D38225

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



06.11.27 @



Comment: SECOND CHECK

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB/08/11/27

(22)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

9.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING  
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

V PA 01.12.01

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

N/A

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 08.10.30

RELEASED

AUTH

DATE

08.12.01 Prototype

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

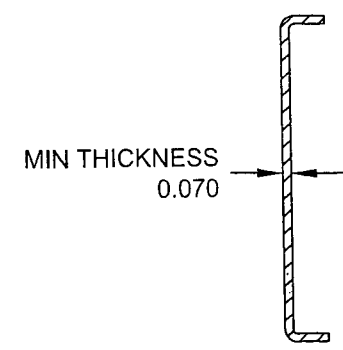
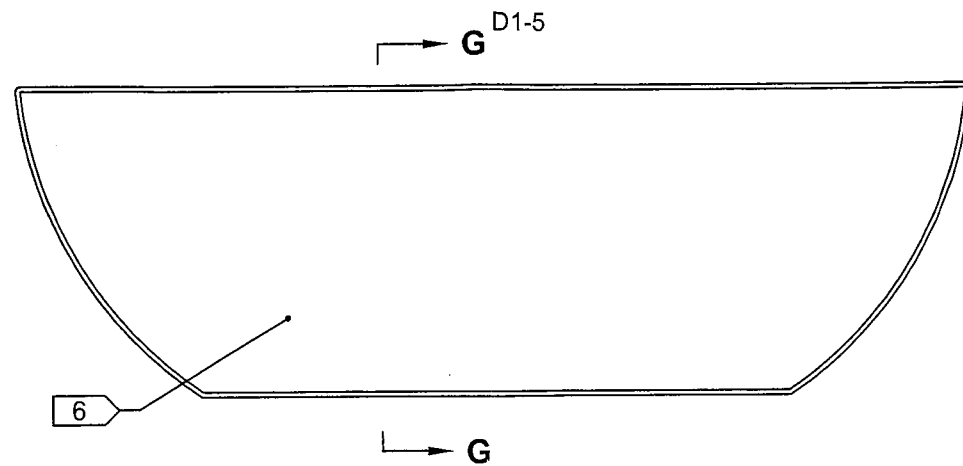
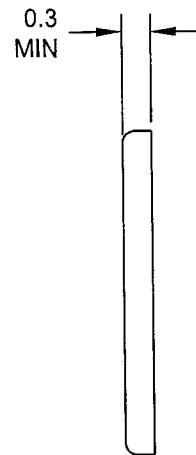
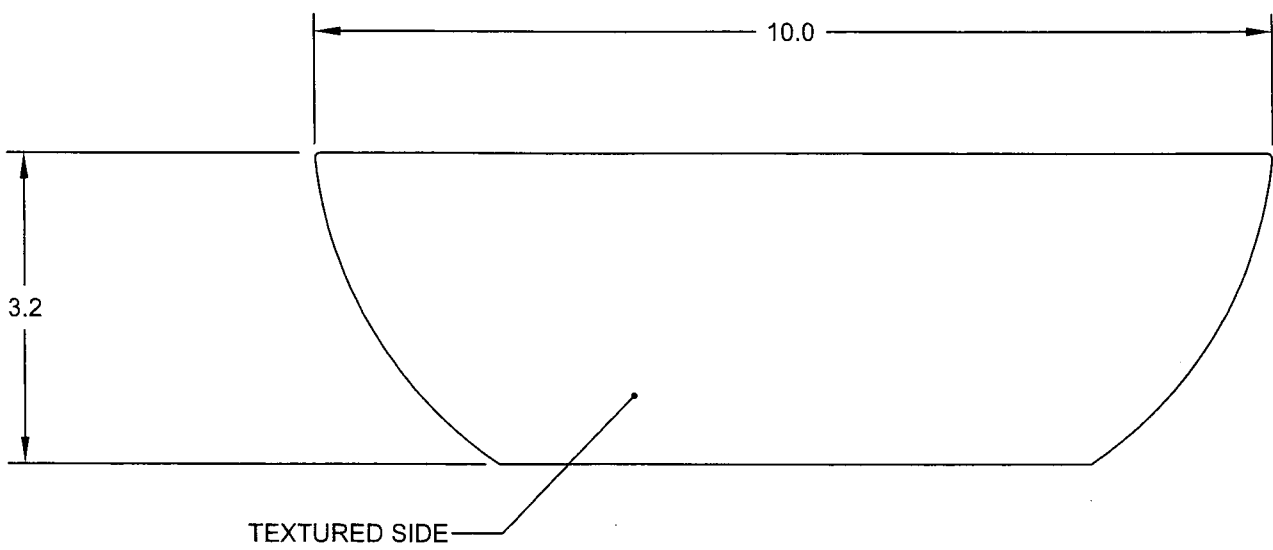
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

D  
C  
B  
A

D  
C  
B  
A



SECTION G-G C2-5

**D3822-5 VERTICAL TUNNEL, TOP**

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
08.11.07 *RS*

- NOTES:**
- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015  
(REF DART SPEC MKYD6185S.080-P3-62015)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3822-5" USING VIBRATING STYLUS
  - 7) WEIGHT: 0.14 lbs
  - 8) TOOLING: THERMOFORM PER MOLD DT9078 PER DART QSI 022

DESIGN	<i>RS</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>RS</i>		
CHECKED	<i>RS</i>	DRAWING NO.	REV. A
MFG. APPR.		D3822	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL TUNNEL	NTS
DATE	08.09.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

# Receiving Report

**Date:**

**Batch No:**

Dart P/O:

Packing Slip:	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Invoice:	Yes	<input type="checkbox"/>	No	<input checked="" type="checkbox"/>
Receipt:	Cash	<input type="checkbox"/>	Cr	<input checked="" type="checkbox"/>

[illegible]

### Discrepancies

Discrepancies						
Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12           

**Admin:**

Location \_\_\_\_\_



**SABIC Polymershapes**

250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3  
TEL: 613 745 7043 FAX: 613 745 8163

## CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER : 7280

OUR SHIPPER NO: 084287

LINE ITEM # : 1

QUANTITY: 51

54 804287

084287

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

Jon Caldwell

JON CALDWELL  
BRANCH MANAGER

DART AEROSPACE LTD		Work Order: 43099
Description: Vertical Tunnel Top / Prototype		Part Number: D3822-5
Inspection Dwg: D3822 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			Tiny, tiny bumps but acceptable for testing

Measured by: BB

Date: 08/11/27

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.0	± 0.100	10.0	✓			
3.2	± 0.100	3.223	✓			
0.3	min	0.315	✓			
0.070	min	0.072	✓			

Measured by: BB

Date: 08/11/27

Audited by: [Signature]

Date: 08/11/27

Prototype Approval: [Signature]

Date: 08.12.01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	